



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D2574
Job Sheet 179311



Part No: D2574

Job Qty: 8 ea

Part Name: Saddle, Aft, In



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 6/16/18

Job Tracking No:

Due Date: 7/6/18

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV F IFP Rev: I As Per RevE 06-01-27 JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	8 Ea		7/6/18	0.00	0.00	Start Up Machining		SBL 18/07/20
100	CNC Vertical Machining	8 pcs		7/6/18	1.21	12.50	HAAS 1		SBL 18/07/23
110	Mill Conv	8 pcs		7/6/18	0.00	1.00	Mill.Conv 1		SBL 18/07/23
120	QC	8 pcs		7/6/18	0.00	0.00	QC2		SP 18-08-08
130	QC	8 pcs		7/6/18	0.00	0.00	QC8		SP 18-08-08
140	HandFinish	8 pcs		7/6/18	0.00	0.32	HandFinish1		SP 18-08-09
150	Powdercoat	8 pcs		7/6/18	0.00	0.26	Powdercoat1		SP 18-08-09
160	QC	8 pcs		7/6/18	0.00	0.00	QC3		SP 18-08-09
170	Packaging	8 pcs		7/6/18	0.00	0.00	Packaging3		SP 18-08-09
180	QC21-SA	8 Ea		7/6/18	0.00	0.00	QC21		SP 18-08-09

Part Op 100 - Program Batch No. 5094538 Machine Step No 1 per Folio FA051 and inspect per attached Dimension Sheets
Descriptions: 2-Machine Step No 2 per Folio FA051 and inspect per attached Dimension Sheets
110 - Machine keyway as per dwg D2573 & D2574
150 - START TIME: _____ FINISH TIME: _____

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D6101-005	Saddle Billet	8 Ea (1 ea)	90-Start up Operation	5059502

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D6101-005	8	54	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Saddle, Aft Inboard	0.438Inches + 0.005 - 0.000	0.443 0.438		
2	Saddle, Aft Inboard	1.745Inches + 0.010 - 0.000	1.755 1.745		
3	Saddle, Aft Inboard	3.495Inches + 0.010 - 0.000	3.505 3.495		
4	Saddle, Aft Inboard	1.745Inches + 0.010 - 0.000	1.755 1.745		

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION	AGAINST DEPARTMENT/PROCESS				
	Rework ☐	Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	
	Scrap ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	
	Use-as-is ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	
	Suspected Unapproved ☐	Large Fab ☐	Composite ☐	Supplier ☐		

Date :	Step #:	QTY Effective :	MRB (QSI042) Approval
Description Work Order Deviation		Disposition	Completed By
			Lead hand / Supervisor Approval Verification
			QC / QA Coordinator Approval

Root Cause	
Environment ☐	No Re-ve ☐
Design ☐	Operator ☐
Doc/Data ☐	Offset/Se ☐
Equip/Tooling ☐	Supplier ☐
Handling/Pre ☐	Training ☐
Material ☐	Use for Tr ☐
Internal Transport ☐	Poor Info ☐
Tribal Knowledge ☐	Rushing ☐
LOA ☐	Product I ☐
Substation ☐	Process I ☐
Past Expiry Date ☐	Manufac ☐
Misidentified ☐	Past Due ☐

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CANADA
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Container No: S094538
Part: D2574
Job No: 179311
Serial No/Batch: S094538
Revision: Rev.F
Inspector:
Exp Date:
Instructions: D2574 Rev C, sheets 1-3 Date: 07/20/16

s/Surge ☐	Positioned Wrong
ram ☐	Outside Dimensions
	Over/Under tolerance
	Part Incorrect
ick Pulled ☐	Part Lost/Missing
uence ☐	Part Moved
	Drawing
d ☐	Finish
on ☐	Misread
d/off center ☐	Turning Sequence

5	Saddle, Aft Inboard	7.990Inches	+ 0.020 - 0.000	8.010 7.990
6	Saddle, Aft Inboard	0.490Inches	+ 0.020 - 0.000	0.510 0.490
7	Saddle, Aft Inboard	0.257Inches	+ 0.005 - 0.000	0.262 0.257
8	Saddle, Aft Inboard	0.375Inches	+ 0.005 - 0.000	0.380 0.375
9	Saddle, Aft Inboard	0.490Inches	+ 0.020 - 0.000	0.510 0.490
10	Saddle, Aft Inboard	1.174Inches	+ 0.010 - 0.000	1.184 1.174
11	Saddle, Aft Inboard	0.558Inches	+ 0.020 - 0.000	0.578 0.558
12	Saddle, Aft Inboard	1.174Inches	+ 0.010 - 0.000	1.184 1.174
13	Saddle, Aft Inboard	1.365Inches	+ 0.010 - 0.000	1.375 1.365
14	Saddle, Aft Inboard	2.495Inches	+ 0.010 - 0.000	2.505 2.495
15	Saddle, Aft Inboard	4.119Inches	+ 0.010 - 0.000	4.129 4.119
16	Saddle, Aft Inboard	0.115Inches	+ 0.020 - 0.000	0.135 0.115
17	Saddle, Aft Inboard	0.115Inches	+ 0.020 - 0.000	0.135 0.115
18	Saddle, Aft Inboard	0.240Inches	+ 0.020 - 0.000	0.260 0.240
19	Saddle, Aft Inboard	0.115Inches	+ 0.020 - 0.000	0.135 0.115
20	Saddle, Aft Inboard	0.178Inches	+ 0.020 - 0.000	0.198 0.178
21	Saddle, Aft Inboard	3.210Inches	+ 0.040 - 0.000	3.250 3.210
22	Saddle, Aft Inboard	0.230Inches	+ 0.020 - 0.000	0.250 0.230
23	Saddle, Aft Inboard	0.115Inches	+ 0.020 - 0.000	0.135 0.115
24	Saddle, Aft Inboard	0.307Inches	+ 0.005 - 0.000	0.312 0.307
25	Saddle, Aft Inboard	0.760Inches	+ 0.005 - 0.000	0.765 0.760
26	Saddle, Aft Inboard	0.352Inches	+ 0.020 - 0.000	0.372 0.352
27	Saddle, Aft Inboard	0.470Inches	+ 0.060 - 0.000	0.530 0.470
28	Saddle, Aft Inboard	0.615Inches	+ 0.020 - 0.000	0.635 0.615
29	Saddle, Aft Inboard	0.053Inches	+ 0.020 - 0.000	0.073 0.053
30	Saddle, Aft Inboard	0.240Inches	+ 0.020 - 0.000	0.260 0.240
31	Saddle, Aft Inboard	1.500Inches	+ 0.020 - 0.000	1.520 1.500
32	Saddle, Aft Inboard	0.115Inches	+ 0.020 - 0.000	0.135 0.115
33	Saddle, Aft Inboard	0.240Inches	+ 0.040 - 0.000	0.280 0.240
34	Saddle, Aft Inboard	0.240Inches	+ 0.020 - 0.000	0.260 0.240
35	Saddle, Aft Inboard	2.000Inches	+ 0.020 - 0.000	2.020 2.000
36	Saddle, Aft Inboard	0.023Inches	+ 0.020 - 0.000	0.043 0.023

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation			Disposition		
			Completed By		
			Lead hand / Supervisor Approval Verification		
			QC / QA Coordinator Approval		
Root Cause		FAULT CATEGORY			
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____			
Misidentified ☐	Past Due ☐				

DART AEROSPACE LTD	Work Order: 179 311
Description: Saddle, Aft Inboard	Part Number: D2574
Inspection Dwg: D2574 Rev. F	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2574 Rev. E and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.438	0.443		.438	.438	.438	.438		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.750	1.750	1.750	1.750		
E	7.990	8.010		8.003	8.002	8.002	8.002		
F	0.490	0.510		.498	.499	.505	.499		
G	0.257	0.262		.257	.257	.257	.257		
H	0.375	0.380		.375	.375	.375	.375		
I	0.490	0.510		.500	.500	.500	.500		
J	1.174	1.184		1.179	1.179	1.179	1.179		
K	0.558	0.578		.569	.568	.567	.568		
L	1.174	1.184		1.179	1.179	1.179	1.179		
M	1.365	1.375		1.369	1.370	1.370	1.369		
N	2.495	2.505		2.500	2.500	2.500	2.500		
O	4.119	4.129		4.124	4.124	4.125	4.124		
P	0.115	0.135		.133	.128	.130	.133		
Q	0.115	0.135		.124	.124	.124	.124		
R	0.240	0.260		.252	.252	.252	.252		
S	0.115	0.135		.125	.123	.128	.126		
T	0.178	0.198		.188	.188	.188	.188		
U	3.210	3.250		3.232	3.230	3.230	3.230		
V	0.230	0.250		.240	.240	.246	.240		
W	0.115	0.135		.133	.133	.133	.133		
X	0.307	0.312		.311	.311	.311	.312		
Y	0.760	0.765		.760	.760	.760	.760		
Z	0.352	0.372		.367	.367	.367	.365		
AA	0.470	0.530		.500	.500	.500	.500		
AB	0.615	0.635		.625	.625	.627	.624		
AC	0.053	0.073		.060	.058	.059	.058		
AD	0.240	0.260		.249	.250	.250	.250		
AE	1.500	1.520		1.510	1.510	1.510	1.510		
AF	0.115	0.135		.120	.128	.130	.125		
AG	0.240	0.280		.270	.260	.260	.260		
AH	0.240	0.260		.249	.249	.249	.249		
AI	2.000	2.020		2.000	2.000	2.000	2.000		
AJ	0.023	0.043		.033	.033	.033	.033		

Accept/Reject

Measured by:	57
Date:	9-89 18/07/21

Audited by:	mm
Date:	12/12/19

Rev	Date	Change	Revised by	Approved
B	02.09.27	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	
F	13.03.07	Dwg Rev updated	KJ	

DART AEROSPACE LTD		Work Order: 179 311	
Description: Saddle, Aft Inboard		Part Number: D2574	
Inspection Dwg: D2574 Rev. F		Page 1 of 1	

Inspect dimensions highlighted on inspection sheet drawing D2574 Rev. E and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				5 *	6 *	7 *	8 *		
A	0.438	0.443		.438	.438	.438	.438		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.750	1.750	1.750	1.750		
E	7.990	8.010		8.002	8.002	8.002	8.002		
F	0.490	0.510		.494	.498	.501	.498		
G	0.257	0.262		.257	.257	.257	.257		
H	0.375	0.380		.375	.375	.375	.375		
I	0.490	0.510		.494	.500	.500	.498		
J	1.174	1.184		1.179	1.179	1.179	1.179		
K	0.558	0.578		.567	.568	.568	.566		
L	1.174	1.184		1.179	1.179	1.179	1.179		
M	1.365	1.375		1.370	1.370	1.370	1.370		
N	2.495	2.505		2.500	2.500	2.500	2.500		
O	4.119	4.129		4.124	4.124	4.124	4.124		
P	0.115	0.135		.133	.130	.128	.129		
Q	0.115	0.135		.124	.124	.124	.124		
R	0.240	0.260		.251	.251	.251	.251		
S	0.115	0.135		.125	.125	.126	.124		
T	0.178	0.198		.188	.188	.188	.188		
U	3.210	3.250		3.230	3.230	3.230	3.230		
V	0.230	0.250		.240	.240	.240	.240		
W	0.115	0.135		.131	.132	.130	.132		
X	0.307	0.312		.312	.311	.311	.311		
Y	0.760	0.765		.760	.760	.760	.760		
Z	0.352	0.372		.365	.365	.365	.365		
AA	0.470	0.530		.500	.500	.500	.500		
AB	0.615	0.635		.623	.625	.627	.624		
AC	0.053	0.073		.060	.060	.060	.061		
AD	0.240	0.260		.251	.250	.250	.250		
AE	1.500	1.520		1.510	1.510	1.510	1.510		
AF	0.115	0.135		.130	.130	.130	.130		
AG	0.240	0.280		.265	.265	.265	.265		
AH	0.240	0.260		.249	.250	.250	.250		
AI	2.000	2.020		2.000	2.000	2.000	2.000		
AJ	0.023	0.043		.033	.033	.033	.033		

Accept/Reject

57

Measured by:	9-89
Date:	18/07/23

Audited by:	
Date:	18/08/23

Rev	Date	Change	Revised by	Approved
B	02.09.27	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	
F	13.03.07	Dwg Rev updated	KJ	